

# Work Order ID 52802

October 14, 2009 11:31:53 AM



Page 1

Item ID: D3798-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Floor

Start Date: 10/14/2009 Start Qty: 3/5.00



Cust Item ID:

Required Date: 10/16/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 09-10-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3798-041

Rev. B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3798-1

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

6061.000

HB 9-10-15

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

\*\*\*template D3798-1T1\*\*\*

HB 9-10-15

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

\*\*\*template D3798-1T1\*\*\*

2) 507/10/15

(X3)

4

Changes done on W.O. 52802

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3798-041

Accept



Setup Start



Revision ID: B

Item Name: Spacepod Floor

Stop



Start Date: 10/14/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 10/16/2009 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 		0.00							
Small Fab	Memo	0.00							
Small Fab	1- C'sink as per dwg D3798-1 2- Deburr if necessary								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

*09/10/15* (3)

*27 8 09/10/15*

(B)

*27 09/10/15*

(X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 52802

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Item ID: D3798-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Floor

Start Date: 10/14/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 10/16/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MD 09/10/15

x3

(P10)

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble D3798-1 to D3798-5 as per dwg

09/10/15 (8)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8/21/09

(x2)

(x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3798-001 PAR #: \_\_\_\_\_ Fault Category: Prod. Small Fabs NCR: Yes No DQA: \_\_\_\_\_ Date: 09-10-28  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: 09-10-28

NCR: <u>52802</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/19	# 170	Dudding Riveting found that only 11 D3798-1 holes do not line up with D3798-5 Reinforcement. L.L. Process/print shifted on w.t.		Scrap and Destroy D3798-1 no Rep/ra	 09/10/19	 09/10/19		 09/10/19

NOTE: Date & initial all entries

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Item ID:	D3798-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Spacepod Floor					
Start Date:	10/14/2009	Start Qty:	5.00			
Required Date:	10/16/2009	Req'd Qty:	5.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo POWDER COAT: Start Time: 9:15AM Oven Temperature: 320°F Finish Time: 9:45AM	0.00  0.00							
			⇒ 24 09/10/20			(X2)	Q		
200  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
			UMD 09/10/20			X2			
210  Small Fab Small Fab	1-Install foam as per dwg D3798 using contact cement A/R Contact Cement batch: 112983 2- Trim foam if necessary	0.00  0.00							
			25 09-10-26						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Item ID: D3798-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Floor

Start Date: 10/14/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 10/16/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ S ealobz

(X2)

230

Identify as per dwg &amp; Stock Location: 2413

0.00



Packaging

Memo

0.00

Packaging

P 9/1/2 6 (2)

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

P 09-10-28

Pl 09-10-24  
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 52802

Parent Item: D3798-041RevA

Parent Item Name: Spacepod Floor


Comments:

Start Date: 10/14/2009

Required Date: 10/16/2009

Start Qty: 5.00 3

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.050  6061-T6 .050 Sheet		Purchased	No			100	sf	164.5716	46.2842			

18-10-15

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	164.5715	
110791	34.5715	
112567	128	
17349	2	

112567

D3798-3RevA

Manufactured No



Spacepod Floor Foam

170 Each 5.0000 5.0000



46206 x 1

51098 x 1

ET 09-10-26

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
46206	1	
51098	4	

D3798-5

Manufactured No



Reinforcement

MS20426AD4-34

Purchased No



Rivet

170 Each 0.0000 5.0000



352807

210 Each 0.0000 165.0000



1715541

EP 09/10/16

EP 09/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

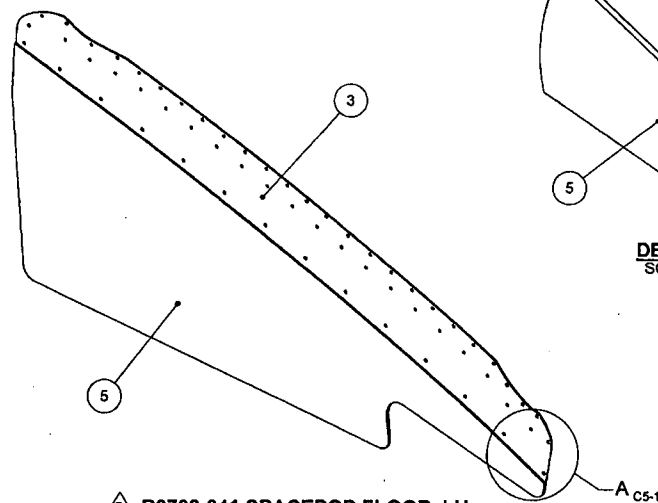
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

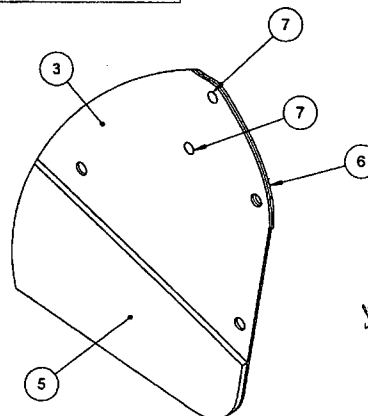
**NOTE:** Date & initial all entries

RELEASED  
2009-10-13

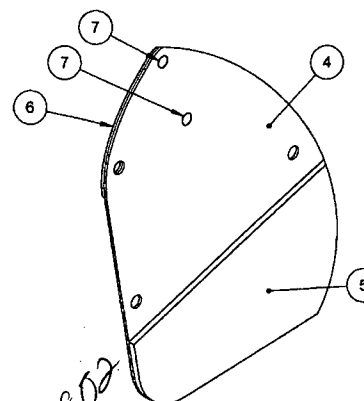
ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D3798-041	SPACEPOD FLOOR ASSEMBLY, LH
2		X	D3798-042	SPACEPOD FLOOR ASSEMBLY, RH
3	1		D3798-1	SPACEPOD FLOOR
4		1	D3798-2	SPACEPOD FLOOR
5	1	1	D3798-3	SPACEPOD FLOOR FOAM
6	1	1	D3798-5	REINFORCEMENT
7	33	33	MS20426AD4-3	RIVET



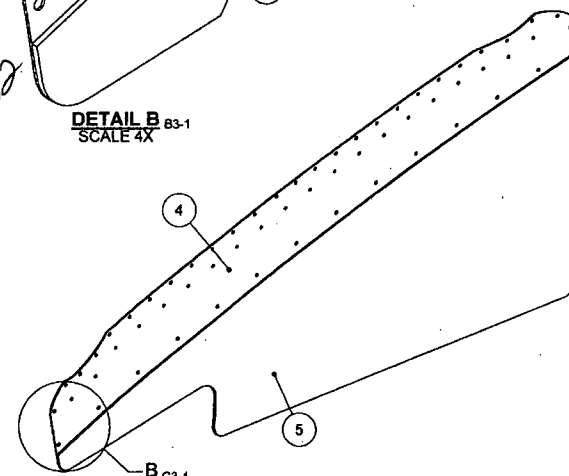
**D3798-041 SPACEPOD FLOOR, LH**



**DETAIL A**  
SCALE 4X



**DETAIL B**  
SCALE 4X



**D3798-042 SPACEPOD FLOOR, RH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3798-041/-042 USING WHITE FINE POINT PERMANENT MARKER
- 7) WEIGHT: D3798-041 - 5.0 lbs  
D3798-042 - 5.0 lbs
- 8) ASSEMBLY INSTRUCTIONS
  - RIVET D3798-5 REINFORCEMENT TO D3798-1/-2 SPACEPOD FLOOR USING RIVETS AS INDICATED
  - POWDER COAT PER NOTE 2
  - INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT.

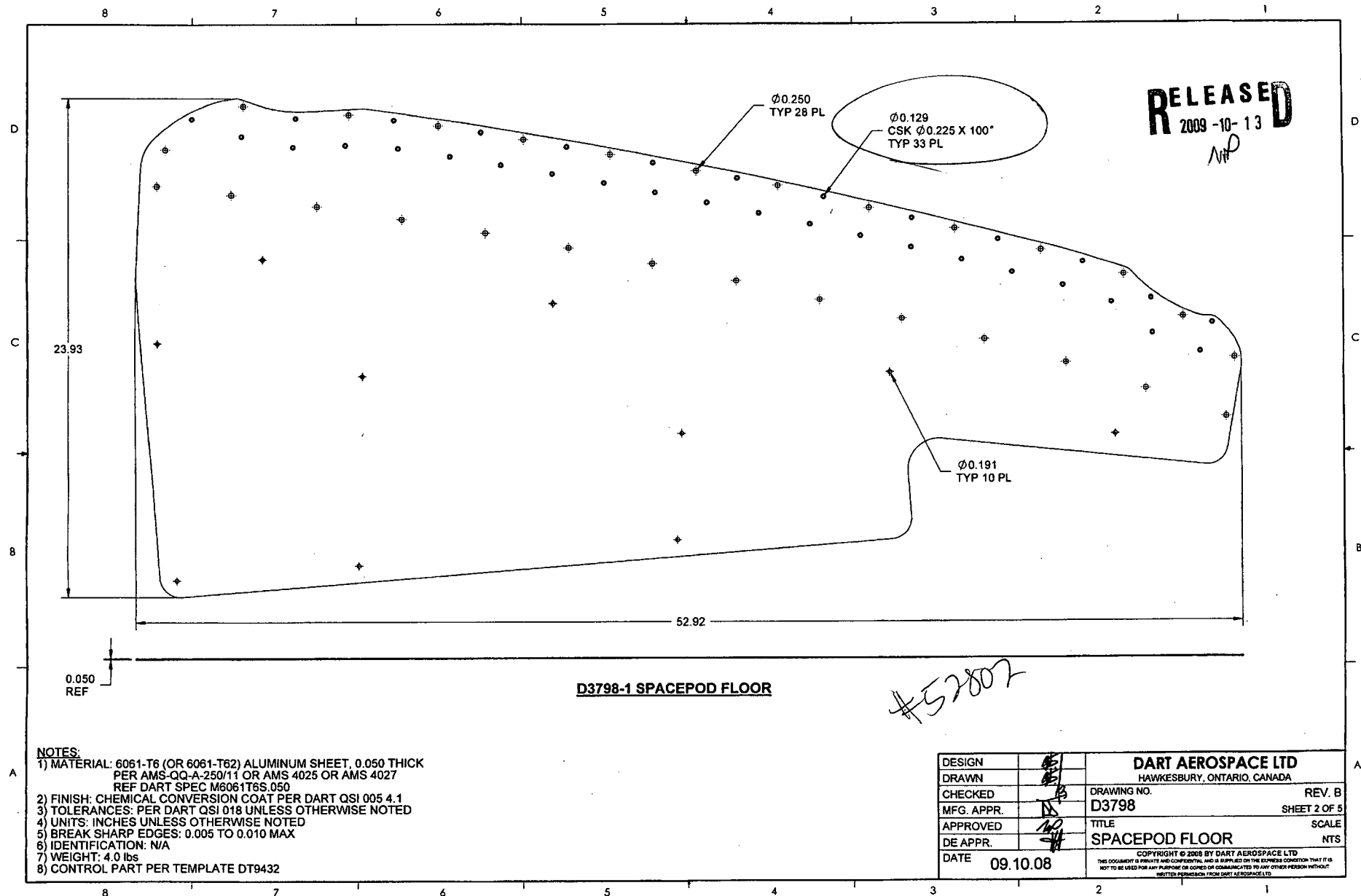
B	ADD 5 (SHEET 4); REVISE -041/-042; ADD ASSEMBLY INSTRUCTIONS (NOTE 8)	HS	09.10.08
A	NEW ISSUE	HS	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.08		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3798** REV. B  
SHEET 1 OF 5  
TITLE **SPACEPOD FLOOR** SCALE NTS

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**RELEASED**  
2009-10-13



**D3798-1 SPACEPOD FLOOR**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.0 lbs
- 8) CONTROL PART PER TEMPLATE DT9432

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3798</b>	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>SPACEPOD FLOOR</b>	NTS
DATE	09.10.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

